

Work Order ID 136185***136185***

Page 1

Friday, August 28, 2015 2:27:25 PM

Item ID: D2002-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Knob

Start Date: 8/28/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2002

Rev A

100

0.00

100

Doosan

Doosan Lathe

Memo

1-Turn as per folio FA005 & dwg

FOLIO REV: AADWG REV: N/A

2-Deburr as required

0.02

4ØDAS
40
9-89

15/09/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

4ØDAS
40
9-89

15/09/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

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Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 44 9-89
120						4	0		SEP 09/10
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: GA	0.00							
130									
Packaging	Memo	0.00			DAS 30 9-89	4			SEP 10 2015
Packaging	LOCATION : GA								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MCS SEP 10 2015

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, August 28, 2015 1:58:35 PM

Page 1

Work Order ID: 136185

136185

Parent Item: D2002-015

D2002-015

Parent Item Name: Knob

Start Date: 8/28/2015

Required Date: 8/28/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.05.18Added inspection level 8EC
IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased		No			f	9.8150		0.2			DAS
MDFI RINR1 2500									**			15/09/10	40
DELIN ROUND BAR 1.25" color: black													

Location

Loc Qty

Loc Code

MAT039

9.815

✓

m131782

9.815

.250

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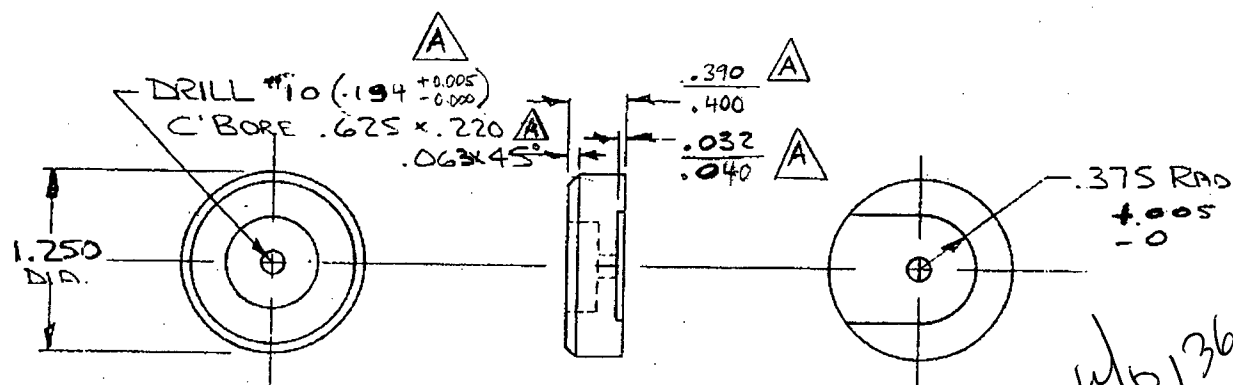
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OTHER : _____					

79.12.09 DC



DETAIL OF D2002-015

4/F: BLACK DELRIN OR
A BLACK UHMW PER D2689



REVISION DRAWN CHECKED APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		PART NO. _____ ITEM _____ DESCRIPTION _____ MATERIAL _____ SPEC./VENDOR _____	
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL:		LIMITS:		DART AERO ACCESSORIES INC.	
1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES: FIN. 3. REMOVE SHARP EDGES 0.015 MAX. 4. THREADS PER MIL. S-7747 5. HOLE PER LAND 10377		1. TOLERANCES - JOE 2 0.009 2. ANGLES JOE 2 0.10 3. Holes 0.001 4. PERMANENTLY 0.0020 5. RECENTRICITY 0.004 MAX. 6. SYMMETRY ABOUT ALL HOLE CENTER LINE'S 0.05		CONTRACT NO. _____ DRAWN BY: BROADLEY DATE: 7/10/78 CHECKED BY: BROADLEY DATE: 7/10/78 STRESS _____ CHECKED _____ CUBIC _____	
REPORT ALL DISCREPANCIES - DO NOT SCALE		BASIC CODES 88-4451041040 88-4451041040		TITLE: KNOB CODE: D 2002 SCALE: 1:1 SHT: 1 OF 2	

2002-015

DQA: _____ Date: _____



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OTHER :					